

Work Order ID 71964

Thursday, July 14, 2011 11:02:08 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 7/14/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2230	Rev G

100 0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: _____

cut extrusion @ meter

CL 11/05/14

110 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1 *perch*

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV: _____

DWG REV: _____

Check for crack while loading into the machine.

2- deburr

7/10/14 482

issue P10 to meter

Machine as per draw D 2230 REV G

CL 11/05/14 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71964

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Page 2

Item ID: D2230-3

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Item Name: Lug

Start Date: 7/14/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Rec'd + inspect for transit damage
attached c/c to W/O

Rec'd 8/5/100

130



QC

Quality Control

QC6 Inspect parts - second check

0.00

Memo

0.00

8/108/09

*count
7/100*

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*count
100 x 8 21/08/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____, _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

Stop



Item Name: Lug

Start Date: 7/14/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100X ϕ M-11/08/11

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
320 OF
2:30

100X ϕ M-11/08/15

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

100X ϕ M-11/08/16

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 71964

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Page 4

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Stop



Item Name: Lug

Start Date: 7/14/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 7/27/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: SK

0.00



Packaging

Memo

0.00

Packaging

EP 5/14/08/18

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/2211-08-19
100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 14, 2011 11:02:05 AM

Page 1

Work Order ID: 71964



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 7/14/2011

Required Date: 7/27/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC
25 JLM VERIFIED BY:EC
☐ IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	542.9300	0.0683	7.189474			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



CZ 11/07/14

Location

Loc Qty

Loc Code

MAT006

542.93

43722

161.5

45800

1

63005

4.43

68331

376

7.1894

D2230-37

Pu/s

X100

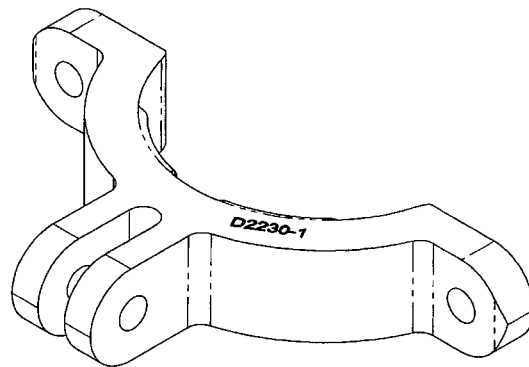
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

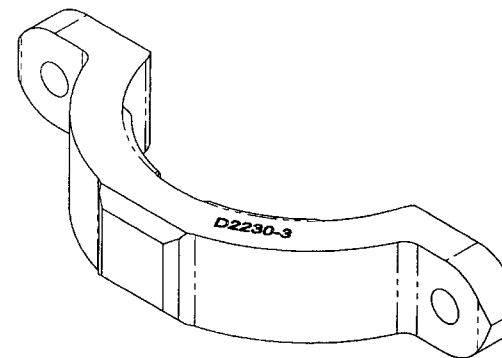
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

CL11107114
W10:7F64

RELEASED
9/16/85 M



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

DESIGN	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DRAWN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS		
MFG. APPR.		DRAWING NO.	REV. G
APPROVED		D2230	SHEET 1 OF 3
DE APPR.		TITLE	SCALE
DATE	09.01.16	MOUNTING LUG	NTS

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8

7

6

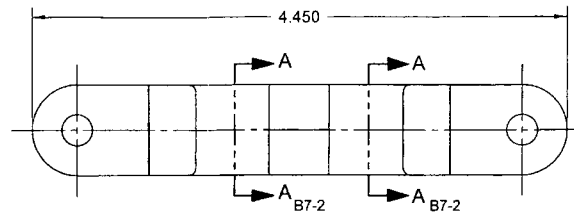
5

4

3

2

1



0.273
REF

SYM ABOUT

FILLET EDGE
PER SECTION
A-A

MACHINE TO
SIZE

0.308

1.200

D2230-1

0.345

R0.125
REF

0.025
REF

0.250

0.735
REF

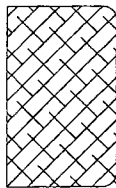
MACHINE TO
SIZE

1.91

0.400

0.025
REF

R0.38
REF



R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A D4.2
SCALE 2X

0.375

3.700

$\phi 0.257^{+0.005}_{-0.000}$

0.750

R0.38
REF

SYM ABOUT

D2230-1 MOUNTING LUG

RELEASED
09/06/75

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8

7

6

5

4

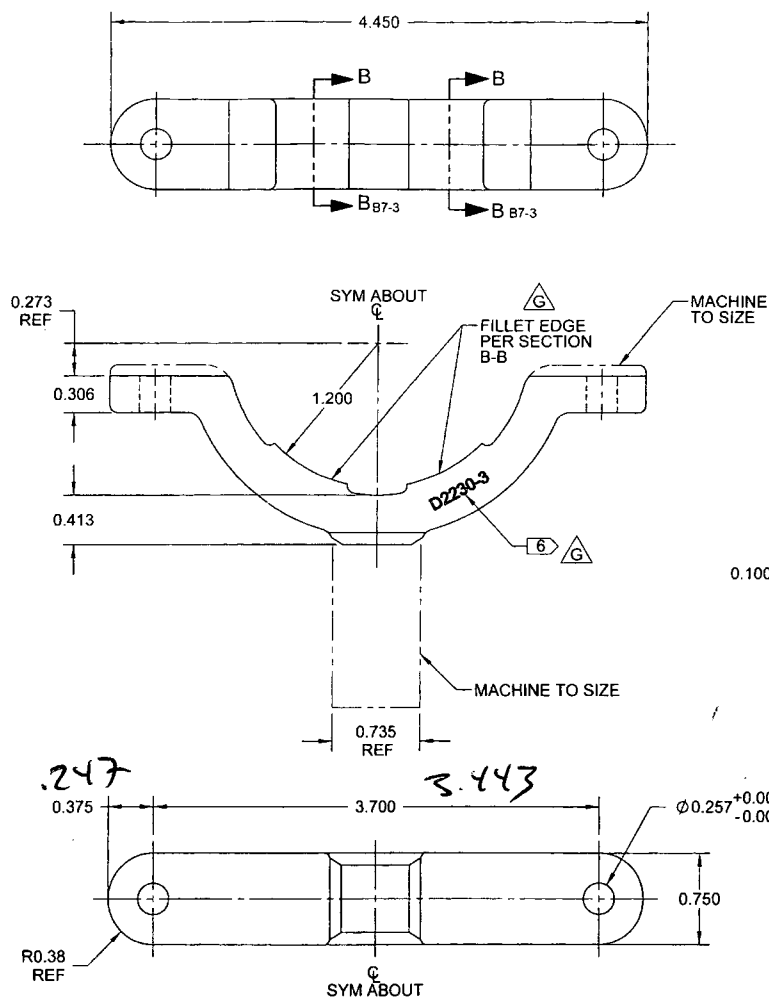
3

2

1

SECTION B-B D4-3
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO14482

Purchase Order Date 7/14/2011
PO Print Date 7/18/2011

Page Number 1 of 1

VC-MET003

Order From:
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
MANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

RECEIVED \$

Ship To: DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2731-7P	LUG	7/27/2011 Yes	50.00 Each		\$16.6500	\$832.50
		Special Inst:	MACHINE AS PER DWG D2731 REV. C B71860				
2	D3235-1P	lug	7/27/2011 Yes	100.00 Each		\$15.0500	\$1,505.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B71965				
3	D2230-3P	LUG	7/27/2011 Yes	100.00 Each		\$13.6000	\$1,360.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B71964				
PO Total:							\$3,697.50

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 7/18/2011



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18112**
Date: Aug 08, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14482	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG Material supplied by DART: D2423 B63005	Each	50		
D3235-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	100	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2230-3

Lug

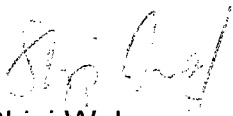
14482

MATERIAL: supplied by DART D2423 B63005

8/10/09

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, August 8, 2011